



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

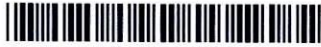
D3204-5
Job Sheet 179766



Part No: D3204-5

Job Qty: 10 ea

Part Name: Arm



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	10 Ea	7/6/18	7/6/18	0.00	0.00	Start Up Machining-2		Marie L 18/07/08
100	Bandsaw	10 pcs	7/6/18	7/6/18	0.00	0.01	Bandsaw1		11
110	CNC Vertical Machining	10 pcs	7/6/18	7/6/18	0.27	3.27	HAAS1-3		11
130	QC	10 pcs	7/6/18	7/6/18	0.00	0.00	QC8 Machining-2		Marie L 18/07/08
140	Packaging	10 pcs	7/6/18	7/6/18	0.00	0.00	Packaging3-1		EL
150	QC21-SA	10 Ea	7/6/18	7/6/18	0.00	0.00	QC21		JUL 11 2018

Part Op 100 - Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000)

Descriptions: 110 - 1- Machine as per Folio FA344 and Dwg D3204 Identify as D3204-5

140 - LOCATION : WA002

DAS
21
9-00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X01.250	6061-T6 Bar .375 X 1.25	2.9130 ft (.2913 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.375X01.250	3	19	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	0.375Inches ± 0.010	0.385 0.365	Radius	
2	Arm	0.750Inches ± 0.010	0.760 0.740		
3	Arm	0.500Inches ± 0.030	0.530 0.470	Radius	
4	Arm	0.500Inches ± 0.010	0.510 0.490	Radius	
5	Arm	0.760Inches + 0.005 - 0.000	0.765 0.760	Diameter	
6	Arm	0.080Inches ± 0.010	0.090 0.070		
7	Arm	2.373Inches ± 0.005	2.378		

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

			2.368	
8	Arm	0.375Inches + 0.005 - 0.000	0.380 0.375	Diameter
9	Arm	0.250Inches ± 0.010	0.260 0.240	
10	Arm	0.060Inches ± 0.030	0.090 0.030	Radius
11	Arm	0.200Inches ± 0.010	0.210 0.190	

Plex 6/21/18 8:35 AM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S089779

Part: D3204-5
Job No: 179766
Serial No/Batch: S089779

Revision:
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/06/18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								